

Work Order ID 106042

October-02-13 8:10:50 AM

Rec'd
106042

Page 1

Item ID: D3512-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stainless Steel Wearplate

Start Date: 8/28/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/28/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *W* Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3512	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

24 0 Jm 13-10-03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

24 0 Jm 13-10-03

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Required Date: 8/28/13 **Req'd Qty:** 16.00

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Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary

Form as per dwg D3512 using DT8179

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0,00

Quality Control

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Cust Item ID:

Required Date: 8/28/13

Req'd Qty: 16.00

16

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Large Fab

Large Fab

0.00

Memo

0.00

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

Large Fab

Batch A/R 2059b Hardcoat Rod **M126843****24****13-10-07 MAL**

160

160

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

25**13.10.07****D4
09
89**

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

25**13.10.07****D4
09
89**

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Item ID: D3512-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 8/28/13 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 8/28/13 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
180 Powdercoat Powder Coating	Memo START TIME: 3:30 OVEN TEMPERATURE: 320°F FINISH TIME: 4:00	0.00							24X ✓ M 13/10/07
190	QC3- Inspect Part Finish	0.00							
190 QC Quality Control	Memo	0.00							DAS 16 9-89 13/10/07 24 SMO 13/10/07
200	Identify as per dwg & Stock Location: 21X 5T500	0.00							
200 Packaging Packaging	Memo PPP: 105713 (1x) PPP: 105789 (2x)	0.00							24X DAS 28 9-89 13-10-8

M 125028

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16

Cust Item ID:

Required Date: 8/28/13

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00


210

QC

Memo

0.00

Quality Control

 / RM 13/10/08MF
13-10-08

Picklist Print

October-02-13 8:11:37 AM

Page 1/1

Work Order ID: 106042

Parent Item: D3512-1

Parent Item Name: Stainless Steel Wearplate

Start Date: 8/28/13

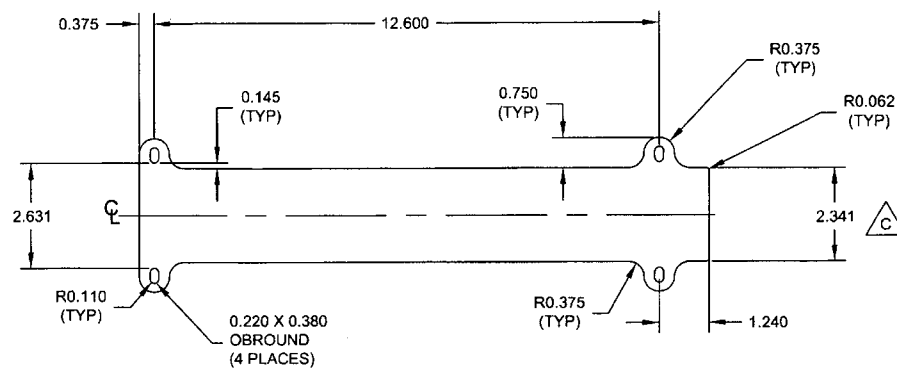
Required Date: 8/28/13

Start Qty: 16.00

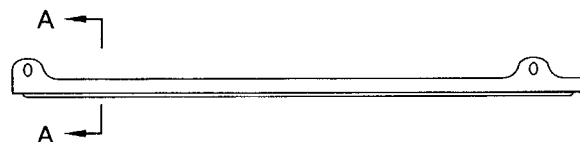
Required Qty: 16.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

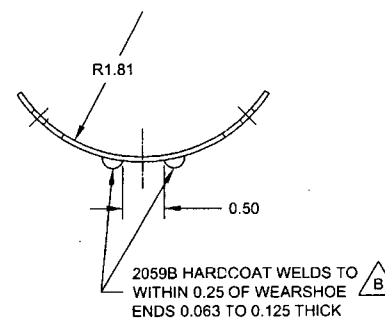
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No				sf	526.8940		16.0 ¹⁸ 10.0			Jm13-10-03
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		526.8939998							
				123136		140.2							
				M126159		35							
				<u>M126915</u>		351.694							
										126915 →			



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

RELEASED
07.11.16

C	ENLARGE OBROUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3512
TITLE WEARPLATE
SCALE 1:3

REV. C
SHEET 1 OF 1

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